

Work Order ID 84611

May-17-12 10:38:22 AM

84611

Page 1

Item ID: D350-567-115

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Interior Floor Window

Stop

NS2

Start Date: 17/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/13 Tooling:

Date:

Run

Start

NR1

QC: _____

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-567	Rev D

100 0.00

100 DOCUMENT CONTROL

DC Memo 0.00

Document Control Photocopy bluefile and create labels per PPP D350-567-115 CHG004 JB

4 W 12-06-13

JB For MLJ 12-5-30
(LABEL ONLY) (4)

110 0.00

110 Packaging

Packaging Memo 0.00

Packaging

4 12/05/30 JB

120 0.00

120 QC

Quality Control Memo 0.00

4 W 12-06-13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84611

May-17-12 10:38:22 AM

84611

Page 2

Item ID: D350-567-115

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Interior Floor Window

Stop

NS2

Start Date: 17/05/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 31/05/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**
130

130

Packaging

Packaging

**Operation
Description**

Packaging

Memo

Identify and pack for shipping as per PPP D350-567-115

Location:

PPP Rev: *PPA84609*

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/6/13 Q

12/6/14 AD

MLJ 12/6/13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-17-12 10:38:27 AM

Page 1

Work Order ID: 84611

84611

Parent Item: D350-567-115

D350-567-115

Parent Item Name: Interior Floor Window

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 04-08-24 JLM
 IPP Rev:B CHG#2 ECN 1055 07-11-21 DD verified by:EC
 IPP Rev:C 08-10-07 as per revD DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C632R12		Purchased	No		110	Each	117.0000	9	36	✓	JB	Z
--------------	--	-----------	----	--	-----	------	----------	---	----	---	----	---

AN526C632R12

Screw

Location Loc Qty Loc Code

ST346	50	
121556	50	
ST347	67	
119225	67	

119225

D2463		Manufactured	No		110	f	733.4972	4.41	17.64	✓	JB	Z
-------	--	--------------	----	--	-----	---	----------	------	-------	---	----	---

D2463

Seal

Location Loc Qty Loc Code

ST404	733.49717	
72232	15.38	
79478	218.11717	
83542	500	

79478

1X (d2463-0530 AS PER DWG) CUT TO 53.00"

D3293-1		Manufactured	No		110	Each	4.0000	0	4	✓	JB	12/05/30
---------	--	--------------	----	--	-----	------	--------	---	---	---	----	----------

D3293-1

Doubler

Location Loc Qty Loc Code

ST211	4	
80172	4	

80172

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-17-12 10:38:27 AM

Page 2

Work Order ID: 84611

84611
D350-567-115

Parent Item: D350-567-115

Parent Item Name: Interior Floor Window

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3294-01

D3294-1

Bracket

Manufactured No 110 Each 6.0000

U 4
**

✓ JB W

D3295-041

D3295-041

Floor Window

Manufactured No 110 Each 4.0000

U 4
**

74172

✓ JB C

D3296-041

D3296-041

Door Assembly

Manufactured No 110 Each 1.0000

U 4
**

83337

✓ JB C

MS20470AD4-5

MS20470AD4-5

Rivet, Universal Head

Purchased No 110 Each 1,788.000

U 2 8
**

1X 80169

✓ JB 1205130 C

Location Loc Qty Loc Code

ST319 1788

118405 657

120142 1131

120142

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-17-12 10:38:27 AM

Page 3

Work Order ID: 84611

84611

Parent Item: D350-567-115

D350-567-115

Parent Item Name: Interior Floor Window

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-6

Purchased

No

110

Each

3,092.000

015

460

**

MS20470AD4-6

Rivet, Universal Head

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	3092	
117395	16	
118927	291	
119109	12	
120142	773	120142
121524	2000	

MS20470AD4-7

Purchased

No

110

Each

1,503.000

015

60

**

MS20470AD4-7

Rivet, Universal Head

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST139	1186	
121415	1186	121415
ST319	52	
120769	52	
ST320	265	
116081	117	
118614	148	

MS21042L06

Purchased

No

110

Each

280.0000

9

36

**

MS21042L06

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	280	
118354	2	
119109	1	
119758	1	
120360	26	16 20 120360
121444	150	20++ 121444
121556	100	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-17-12 10:38:28 AM

Page 4

Work Order ID: 84611

84611
D350-567-115

Parent Item: D350-567-115

Parent Item Name: Interior Floor Window

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149DN632J

Purchased

No

110

Each

268.0000

9

36

**

JB 12/05/30

NAS1149DN632J

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	268	
118428	268	118428

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY ✓

DART AEROSPACE LTD.

D350-567

Page 28 of 28

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
				1	1	D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1				D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
9	12				2600-6	¼ TURN FASTENER
9	12				2600-LW	WASHER
9	12				212-12	RECEPTACLE
22	21				AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
44	42				AN960JD8	WASHER
22	21				MS21042L08	NUT (OR MS21042-08)
18	24				MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
				1	D3293-1	DOUBLER
				1	D3294-1	BRACKET
				1	D3295-041	FLOOR WINDOW
				1	D3296-041	DOOR ASSEMBLY
				1	D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

* COPYRIGHT © 2000 BY DART AEROSPACE LTD.
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D
 Date: 08.07.08